Work Order ID Wednesday, April 06, 20											Page 1
Item ID: D3490 Revision ID:	-3 Bolt Spacer Start Qty: 60.00		ccept	Cust Item I	~			Setup	Start Stop		
	ss Plan:	Date: 1/104-6 Date:	Tooling: SPC (Y/N):		ite:			Run	Start Stop		
Sequence ID/ Work Center ID Draw Nbr	Operation Description Revision Nbr		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
D3490	Rev A										
Hardinge CNC Lathe Small	FOLIO R DWG RE	AS PER F © LIO FA629 & DWO		nl 11. 4	· /- /	3	26	_			· · · · · · · · · · · · · · · · · · ·
110 QC Quality Control	QC2- Inspect parts off	machine FAI/FAIB	0.00	ad 11.	ý- i	/3	26				

120

QC8- Inspect parts - second check

0.00

Memo

Quality Control

0.00

Dart Aerospace I	Ltd
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W/O:				WO	RK ORDER CHANG	ES				•
DATE	STEP	PRO	CEDUR	E CHAN	GE		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fau	It Categ	ory:	_ NCR:	Yes N	o DQA :	Date: _	
	R	lesolution:	Dist	position	·	_ QA: I	WC Clos	sed:	Date: _	
NCR:		V	VORK	ORDE	R NON-CONFORMA	NCE	(NCR)			
DATE	STEP	Description of NC	Init		Corrective Action Section Action Description		Sign &	Verificatio		Approval
		Section A	Chief		Chief Eng		Date	Section C	Chief Eng	QC Inspector
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Work Order ID 68106



Page 2

Item ID:

D3490-3

Wednesday, April 06, 2011 2:27:37 PM

Accept



Setup Start

Stop



Revision ID:

Cross Bolt Spacer Item Name:

Start Date:

4/6/2011

Start Oty: 60.00

Req'd Qty: 60.00 **Required Date: 4/13/2011**

Operation

Description

Date:

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/ Work Center ID

130

Packaging Packaging

Memo

Memo

Identify as per dwg & Stock Location:

Set Up/ **Run Hours**

0.00

0.00

STOCK IN SKIDTUBE CELL

Tool # Plan Code

Accept Oty

Reject Reject Number

Insp. Stamp

Oty

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

M 11-04-16

	_									
Dart Ae W/O:	rospace L	.td		WORK ORD	ER CHANGES					· + a
DATE	STEP	PR	OCEDURE	CHANGE	·	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
		÷								
Part No		PAR #:								
NCR:	Hes	olution:			CONFORMANC				Date: _	
DATE	STEP	Description of NC	Initia	Corrective	Action Section B n Description	Sign 8	Verifica		Approval Chief Eng	Approva QC Inspect
		Section A	Chie E		Chief Eng	Date		16	Chief Eng	QC Inspect

Picklist Print

Wednesday, April 06, 2011 2:27:44 PM

Work Order ID: 68106

Parent Item:

D3490-3

Parent Item Name: Cross Bolt Spacer



Start Date: 4/6/2011

Required Date: 4/13/2011

Page 1

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	8.5630	0.266	16.8	0		
										1/2	V [[.	\ \frac{1}{2}	13

6061-T6 Round Bar .750"

Location Loc Code Loc Oty MAT013 8.563 0.796 112442 7.767

Dart Ae	rospace L	td									
W/O:				wc	RK ORDER CHA	ANGES					r t
DATE	STEP	PRO	OCEDURE	CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
							į				
		· .									
Part No):	PAR #:	Faul		gory:	NCI	R: Yes	No DO	QA:	Date: _	
	Res	olution:	Disp	osition	n:	QA:	N/C CI	osed: _	,	Date: _	
NCR:			WORK		ER NON-CONFO		(NCF	R)		T	
DATE	STEP	Description of NC Section A	Initia Chie E	al	Corrective Action Action Descrip Chief Eng	Section B tion	Sign 8		ication ction C	Approval Chief Eng	Approva QC Inspect
:											
		**************************************							· · · · · · · · · · · · · · · · · · ·	<u> </u>	

DART AEROSPACE LTD	Work Order:	68106
Description: Crossbolt Spacer	Part Number:	D3490-3
Inspection Dwg: D3490 Rev: A		Page 1 of 1

	FIRST ARTICLE INSPECTION CHECKLIST												
		X First Arti	cle	Prot	otype								
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		nments						
3.085	+0.030/-0.000	3.100			24.0	2	_						
0.080	+/-0.010	,=80											
Ø0.591	+0.008/-0.001	-594											
0.050 x 45°	+/-0.010 x 0.5°	.055											
							. , <u>.</u>						
						_							
							-						
							 						
				<u></u>	-		<u> </u>						
				<u> </u>									
Measured by:	5	Audited by:	Z		Prototype	Approval:	N/A						
Date:	11.4.13	Date:	MATH			Date:	N/A						
Rev Date	Change				<u> </u>	Revised by	Approv@d						
	New Jesus					KI/II M C	r (////						

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHA	NGES				······································	
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								W.		
Part No	•	PAR #:	Fault Cat	tegory:	NC	R: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposit	ion:	Q/	A: N/C CI	osed:		Date: _	·
NCR:		V	VORK ORI	DER NON-CONFO	RMANC	E (NCR	()			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descript	Section B	Sign 8		cation	Approval Chief Eng	Approval QC Inspector
				Chief Eng						



RETURN TO ENGINEERING UNCONTROLLED COPY

	DESIG	PH	DRAWN BY	DART	AEROSPACE PORT HADLOCK		INC.
Ì	CHECK	KED wat	APPROVED AN	DRAWING NO.			REV. X
I		#	-44	D3490		SHE	ET 1 OF
ı	DATE			TITLE			SCALE
	06.0	1.04		CROSS BO	LT SPACER		NTS
	Α		06.01.04	NEW ISSU	JE		

SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

11-04-6 OD : 3.085+0.030 ID 0.050 X 45° CHAMFER (TYP)

D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

1) MATERIAL:

WALL -

ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)

2) ALL DIMENSIONS ARE IN INCHES

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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Dart Aerospace Ltd

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W/O:			W	ORK ORDER CHA	NGES									
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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								<u> </u>						
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Part No	•	PAR #:	Fault Cate	gory:	NO	R: Yes	No DQ	A:	Date: _					
		esolution:			1	A: N/C Clo	osed: Date:							
NCR:		1	WORK ORD	ER NON-CONFO	RMANC	E (NCR))							
NCR:	CTED	Description of NC		Corrective Action	Section B		Verific	cation	Approval	Approval				
	STEP	Section A	Initial Chief Eng	Action Descript Chief Eng	tion	Sign & Date	Secti	ion C	Chief Eng	QC Inspector				
	-													
-	,	4												

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE